
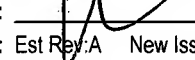


Date: Wednesday, 3/19/2008 7:30:09 AM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GAS SPRING
Job Number :	38105		
Estimate Number :	12941		
P.O. Number :		Part Number :	D355211
This Issue :	3/19/2008	Drawing Number :	D3552 REV C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	C
Previous Run :	36000	Material :	
Written By :		Due Date :	3/21/2008
Checked & Approved By :		Qty:	40
Comment :	Est Rev:A New Issue 06-11-13 EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: Issue P/O: 5949
 Purchase Part Number: B8-240-575-150N
 Supplier: LS Technologies
 Certificate of conformity is required

C208/03/19 (40)

2.0	B8 240 575 150N
-----	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 CARBON STEEL GAS SPRING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure certificate of conformity is attached

Pc 8/3/25 (40)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Test for correct pressure

C 05/03/25 (40)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: ST 439

AR 08/03/25 (40)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/19/2008 7:30:10 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 38105

Part Number: D355211

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



40

Comment: FINAL INSPECTION/W/O RELEASE

AD08103/26

Job Completion



U 08.03.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

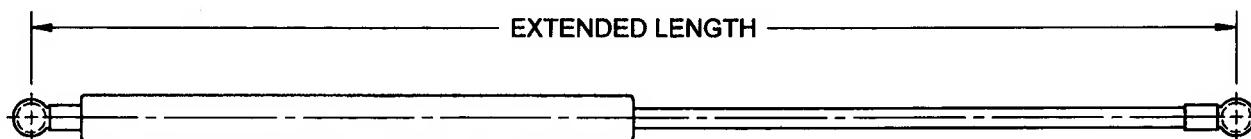
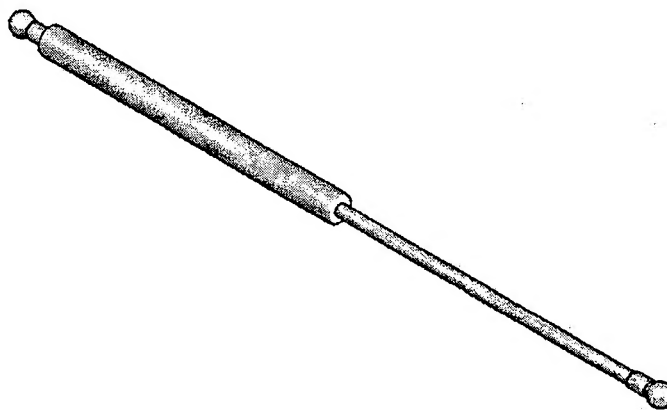
NOTE: Date & initial all entries



DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>TH</i>	DRAWING NO. D3552	REV. C SHEET 1 OF 1
DATE 07.06.01		TITLE GAS SPRING SCALE NTS	
REV	DATE	DESCRIPTION	
A	06.09.15	NEW ISSUE	
B	06.10.24	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	
C	07.06.01	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	

RELEASED
07.07.11
PER BAW #1009

SPECIFICATION CONTROL DRAWING



D3552-X GAS SPRING

DART P/N	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	LS TECHNOLOGIES P/N
D3552-1	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	C8-220-530-070N
D3552-3	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	C8-200-490-200N
D3552-5	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	C8-175-430-150N
D3552-7	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	B6-220-530-070N
D3552-9	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	B8-200-490-200N
D3552-11	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	B8-240-575-150N

NOTE:

1) IDENTIFY WITH DART P/N "D3552-X" USING WHITE FINE POINT PERMANENT INK MARKER

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C208103119
W10: 38105



LS Technologies Canada Inc.

Box 25032
Saskatoon, SK
S7K 8B7

Invoice

Date	Invoice #
3/19/2008	4130

Bill To
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

P.O. No.	Terms	Rep	Ship	Via	F.O.B.	Project
PO00005949	Net 30	Nolan	3/19/2008	Fed-Ex	SASKATOON,SK	

Quantity	Description	Price Each	Amount
40	B-8-240-575-150N GAS SPRINGS	38.30	1,532.00T
	Shipping and Handling FEDEX OVERNIGHT ACCT# 15179324-0 Tracking Number # 7918 6983 1948	0.00	0.00T
	Business Number: 875007718		

Please Pay by Invoice:
No Statement Issued.

- Interest Charges of 2% per month on overdue accounts.
- No products to be returned without prior approval from LS Technologies Canada.
- One year warranty on all gas springs unless otherwise stated.
- We appreciate your business, Thank-You.

GST Can\$76.60

PST Can\$0.00

Total Can\$1,608.60

Phone #	Fax #	LS Technologies E-mail	Web Site
(306) 683-5000	(306) 683-6403	info@lstechnologies.ca	www.lstechnologies.ca